

Date: Thursday, 02/04/2009 2:25:16 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FRAME
Job Number : 46835	
Estimate Number : 13817	
P.O. Number :	Part Number : D23307
This Issue : 02/04/2009 S.O. No. :	Drawing Number : D2330 REV G
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : LARGE FAB ASSY	Drawing Revision : G
Previous Run :	Material :
Written By :	Due Date : 14/04/2009 Qty: 1 Um: Each
Checked & Approved By : <u>SAD 09-04-07</u>	
Comment : Est Rev:A 09.03.18 New Issue EC verified by:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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✓ 1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 2.1210 f(s)/Unit Total : 2.1210 f(s)

304 SQ Tube .75x.75x.065W

batch: M11148

SAD 09-04-07

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- Cut as per dwg D2330

2- Deburr and remove identification markings on tube

SAD 09-04-07 (1)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SAD 09-04-07 (1)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Basket

PD 09-04-07 (1)

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/04/08

Job Completion



09-04-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF

G

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WORK ORDER
NO. 46835

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.75W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF. DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 20 AND 21 REPLACE D2232-1/-3; STRETCHED LID FROM 83.27" TO 84.00"; ITEMS 9 & 10 REPLACE D2330-3/-9/-13; ITEM 13 (ON LID) REPLACES D2327-1; REORGANIZED ALL SECTION & DETAIL VIEWS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JJB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	5		
CHECKED	PH	DRAWING NO.	REV. G
MFG. APPR.	WJ	D2330	SHEET 1 OF 6
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Dart Aerospace Ltd

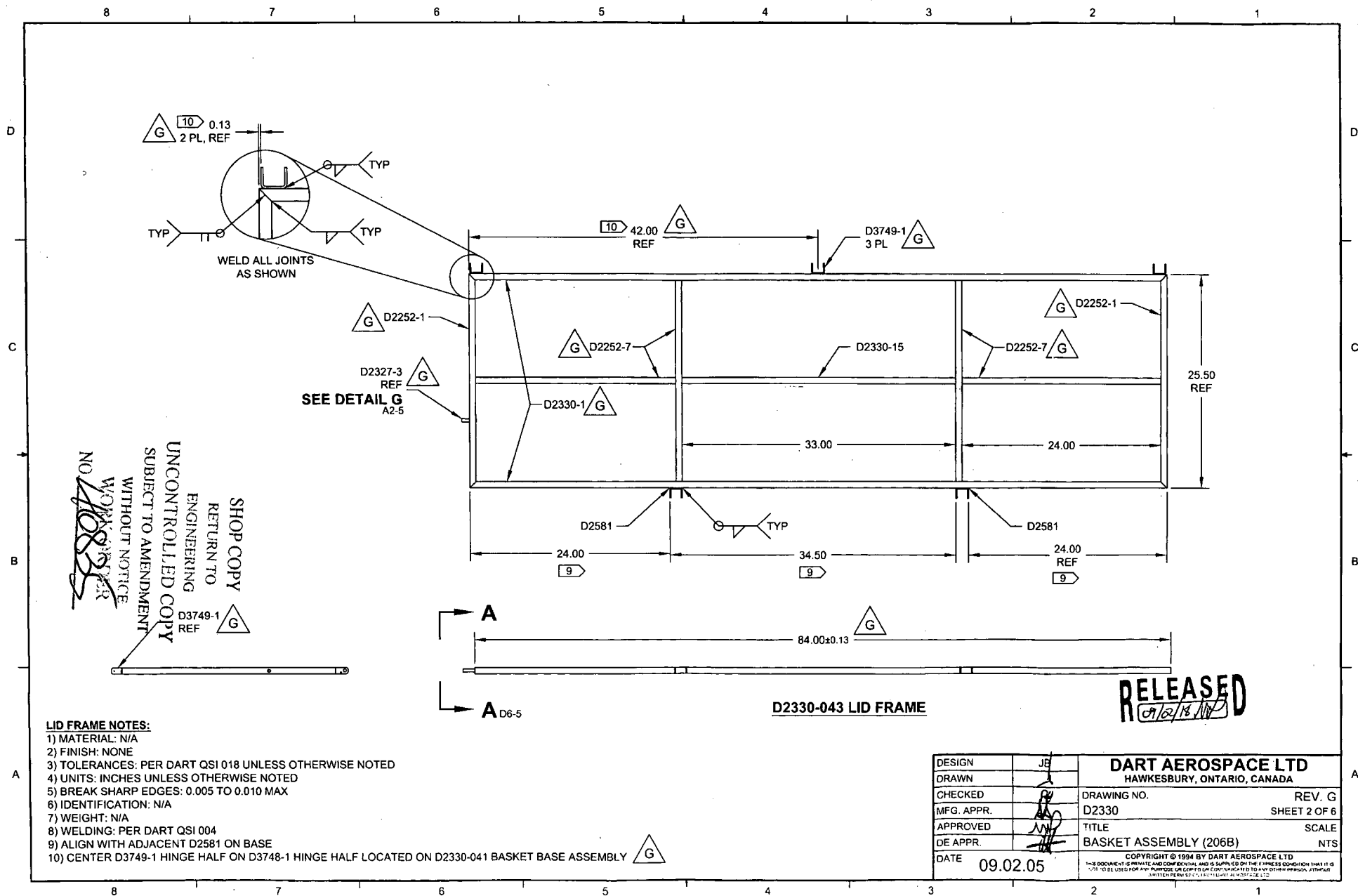
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SEE DETAIL G
A2-5

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LID FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE
- 10) CENTER D3749-1 HINGE HALF LOCATED ON D2330-041 BASKET BASE ASSEMBLY

D2330-043 LID FRAME

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01/21/84

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

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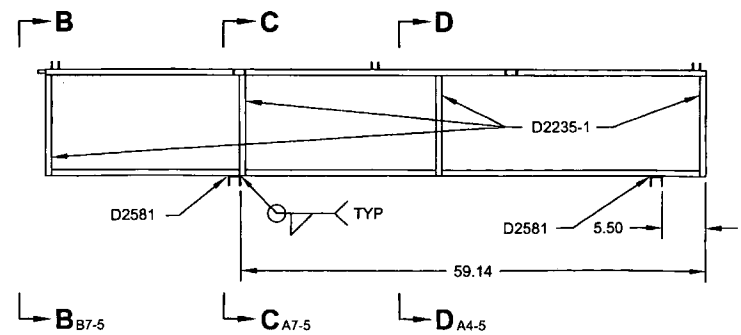
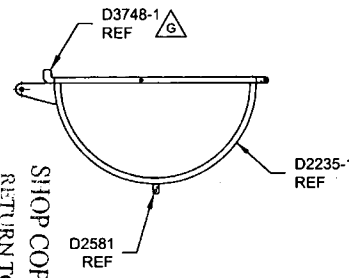
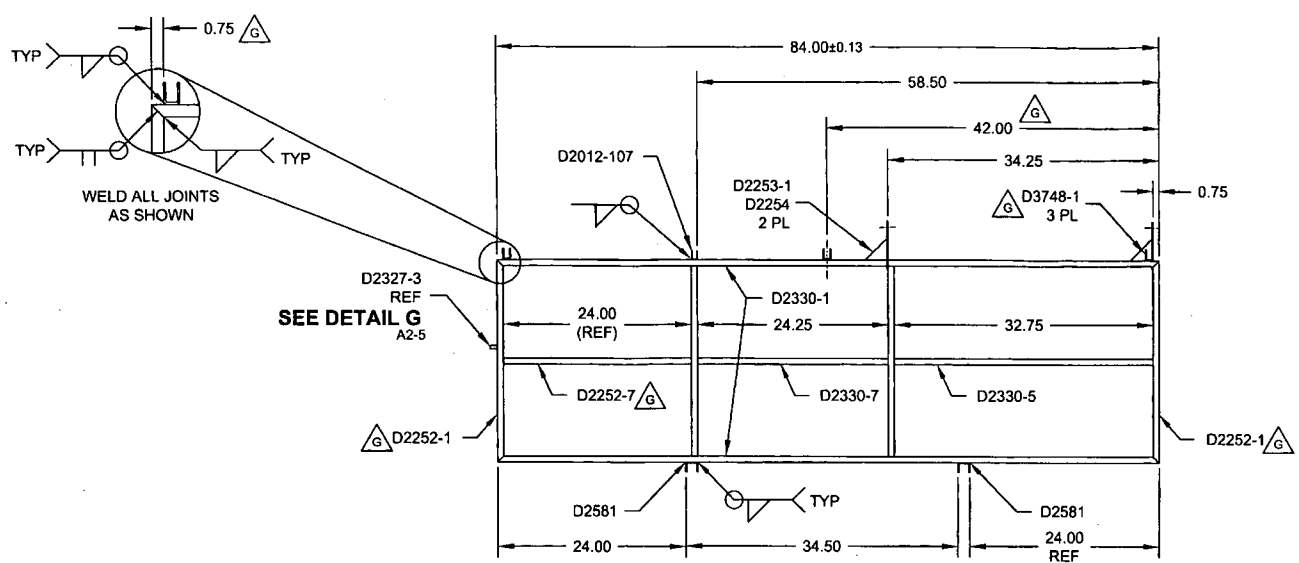
A

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D2330-041 BASE FRAME ASSEMBLY

BASE FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

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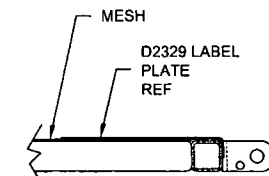
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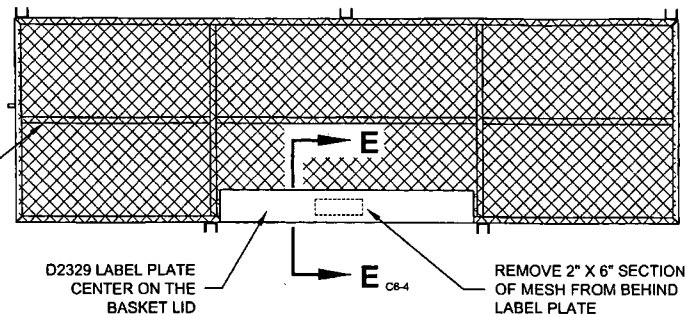
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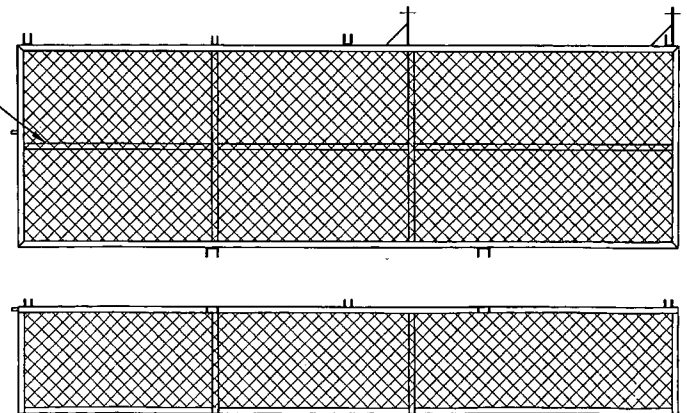


SECTION E-E C3-4
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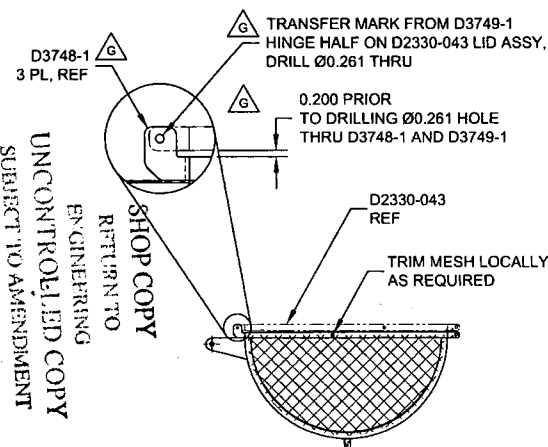
TACK WELD EACH
STRAND END OF
MESH TO FRAME



D2330-043 LID ASSEMBLY



D2330-041 BASE ASSEMBLY



ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

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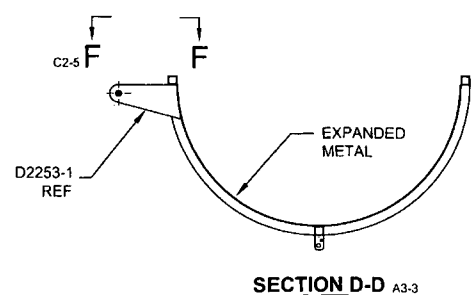
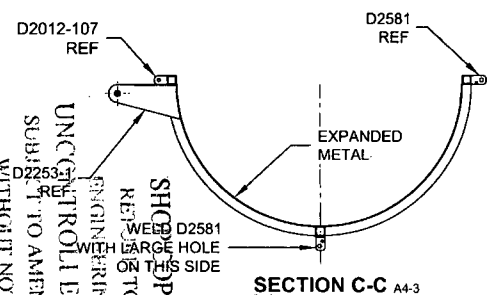
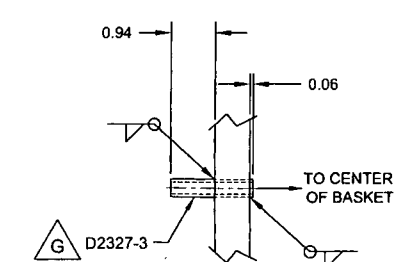
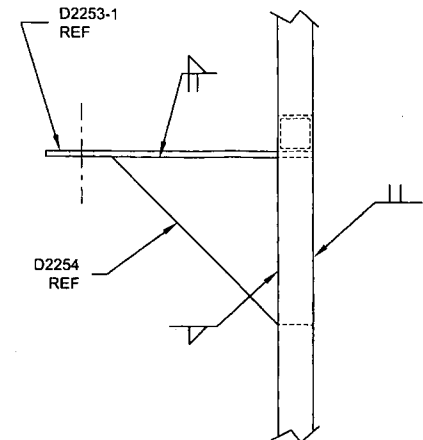
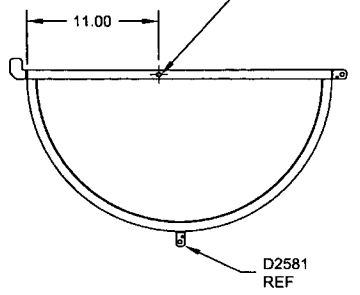
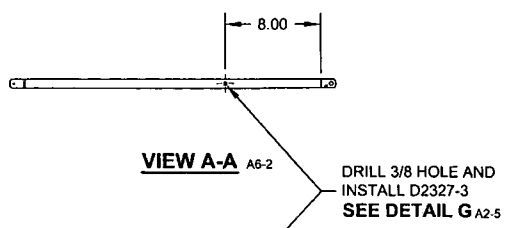
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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8 7 6 5 4 3 2 1

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REF TO
WELL D2581
WITH LARGE HOLE
ON THIS SIDE

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19/12/14

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

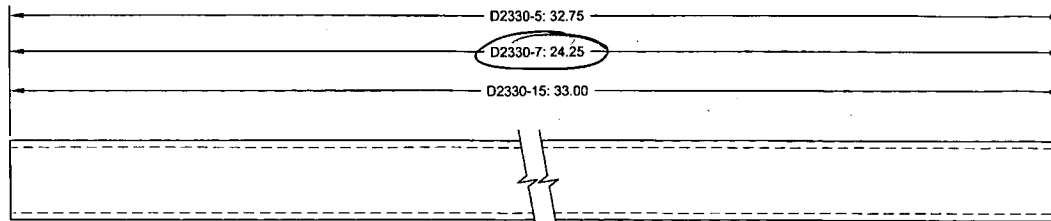
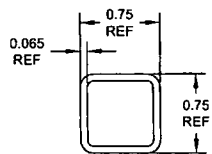
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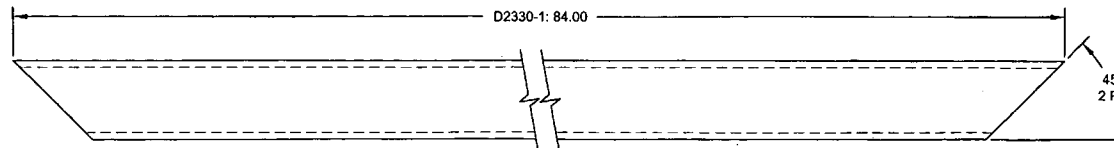
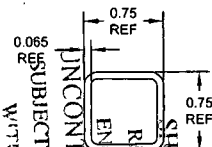
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D2330-5 FRAME
D2330-7 FRAME
D2330-15 FRAME

C

B






D2330-1 FRAME

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9/2/88

- NOTES:
- 1) FRAME MATERIAL: SEE SHEET 1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

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